

# Work Order ID 80923

March-05-12 10:49:12 AM

**\*80923\***

Page 1

Item ID: D2435 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Bearpaw, 206  
 Start Date: 05/03/2012 Start Qty: 4.00 **\*4\*** Cust Item ID:  
 Required Date: 19/03/2012 Req'd Qty: 4.00 **\*4\*** Customer:  
 Reference:

Approvals: Process Plan: MLJ Date: 12/03/05 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D2435	Rev E1								
120	FLOW WATER JET	0.00							
<b>*120*</b>									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	CUT BLANK AS PER FILE D2435								
130	HAAS CNC VERTICAL MACHINING #1	0.00							
<b>*130*</b>									
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	1-Inspect material for defects or damage prior to machining 2-Machine as per Folio FA789 and Dwg D2435 Identify as D2435 3-Deburr								
140	QC2- Inspect parts off machine FAI/FAIB	0.00							
<b>*140*</b>									
QC	Memo	0.00							
Quality Control									

12-03-13 (4)

SL 12/03/17

(4)

SL 12/03/17

(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 80923

**\*80923\***

Page 2

March-05-12 10:49:12 AM

Item ID: D2435 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Bearpaw, 206  
 Start Date: 05/03/2012 Start Qty: 4.00 **\*4\*** Cust Item ID:  
 Required Date: 19/03/2012 Req'd Qty: 4.00 **\*4\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150 QC8- Inspect parts - second check 0.00

**\*150\***

QC Memo 0.00

Quality Control

151 Identify as per dwg & Stock Location: \_\_\_\_\_ 0.00

**\*151\***

Packaging Memo 0.00

Packaging

190 QC21- Final Inspection - Work Order Release 0.00

**\*190\***

QC Memo 0.00

Quality Control

12/03/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

March-05-12 10:49:17 AM

Page 1

Work Order ID: 80923

\*80923\*

Parent Item: D2435

\*D2435\*

Parent Item Name: Bearpaw, 206

Start Date: 05/03/2012

Required Date: 19/03/2012

Start Qty: 4.00

Required Qty: 4.00

## Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10		Purchased	No			120	sf	573.6043	3.2	12.8			
**													
*MUHMWB10*													
UHMW 1" Black													

12.8  
12-03-13

Location	Loc Qty	Loc Code
MAT018	316.48	
120035	74.48	
120401	242	
MAT019	257.1243158	
117321	74.6	
117738	93.28	
117819	83.3	
118814	1.5	
119145	4.44431579	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	80973
<b>Description:</b> Bearpaw		<b>Part Number:</b>	D2435
<b>Inspection Dwg:</b> D2435 <b>Rev:</b> E1		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	0.0645	/		vern	SL-3
B	5.500	+/-0.030	5.500	/		-	
C	0.200	+/-0.030	0.200	/		-	
D	R0.250	+/-0.030	0.250	/		R.G	
E	0.250	+/-0.010	0.252	/		-	
F	0.625	+/-0.030	0.629	/		-	
G	0.25 x 45°	+/-0.030	0.2645	/		-	
H	0.375	+/-0.010	0.377	/			
I	19.000	+/-0.030	19.00	/		m-tape	
J	0.950	+0.030/-0.010	0.952	/		vern	SL-3
K	Ø0.260	+0.005/-0.000	0.260	/		-	
L	Ø0.930	+/-0.030	0.925	/		-	
M	0.30	+0.030/-0.000	0.312	/		-	
N	0.375	+/-0.030	0.377	/		-	
O	7.375	+/-0.030	7.380	/		H.G	
P	4.250	+/-0.010	4.250	/		-	
Q	2.000	+/-0.030	2.015	/		-	
R	9.000	+/-0.010	9.000	/			
S	15.750	+/-0.030	15.750	/		m-tape	

<b>Measured by:</b>	S
<b>Date:</b>	12/03/19

<b>Audited by:</b>	anf
<b>Date:</b>	12/03/19

<b>Prototype Approval:</b>	N/A
<b>Date:</b>	

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue      P/O K10007	KJ/RF	+

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**DART**



DESIGN	DRAWN BY	DART AEROSPACE LTD
KE	KE	HAMMERSBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
KE	KE	D2435
DATE	TITLE	REV. E
98.05.19	BEARPAW	SHEET 1 OF 2
		SCALE
		1:5

RELEASED  
98.06.17 KE

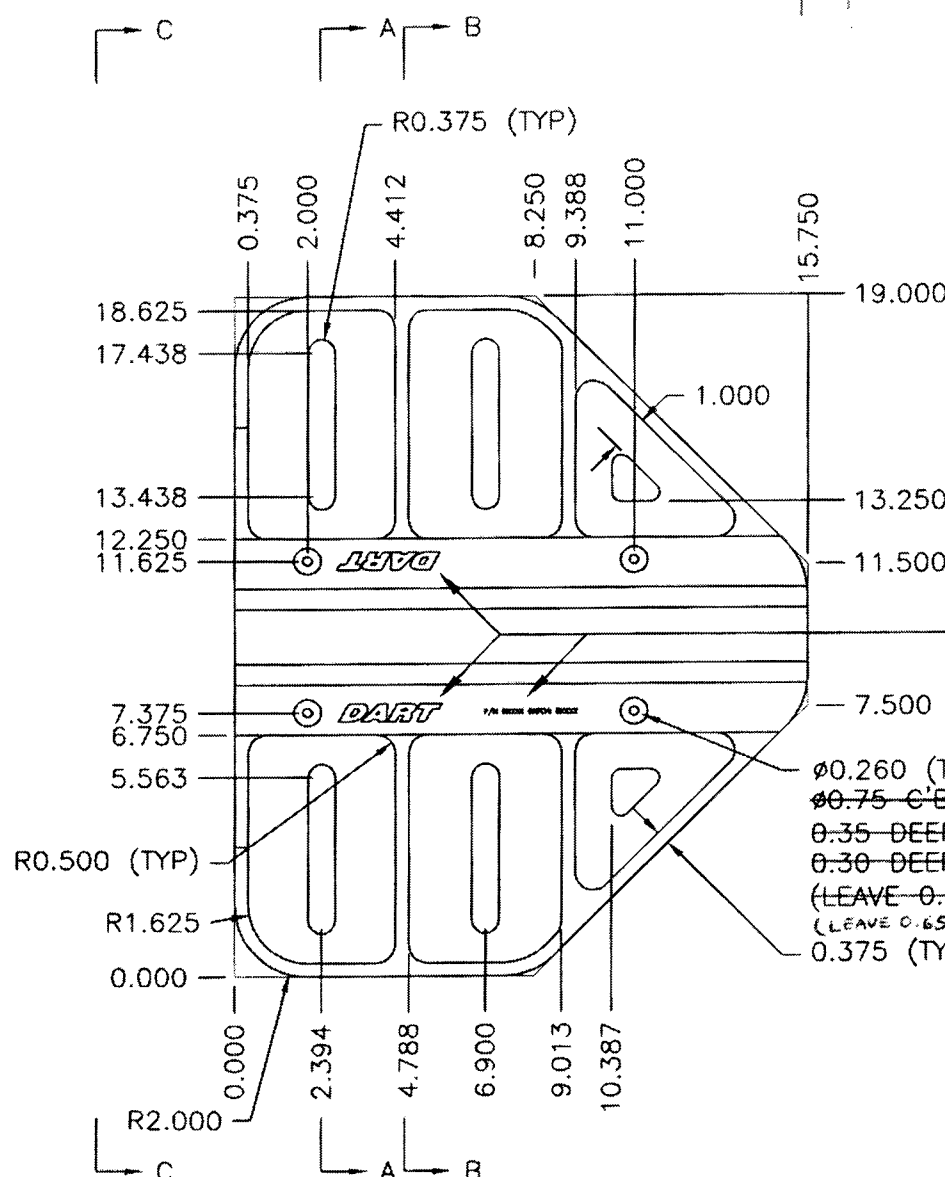
ENGRAVE LOGO TO MAX DEPTH OF 0.012. ENGRAVE PART AND BATCH NUMBERS TO MAX DEPTH OF 0.010. (TYPICAL LOCATION AS ILLUSTRATED)

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 80923MLJ  
12/03/05



EFFECTIVE	DEOS
9143	

E1 02.12.17 0.93 WAS 0.75



MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689  
1.00 THICK (MACHINE TO 0.950)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

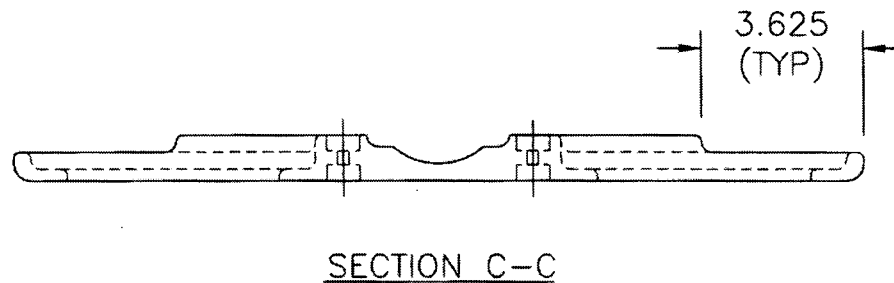
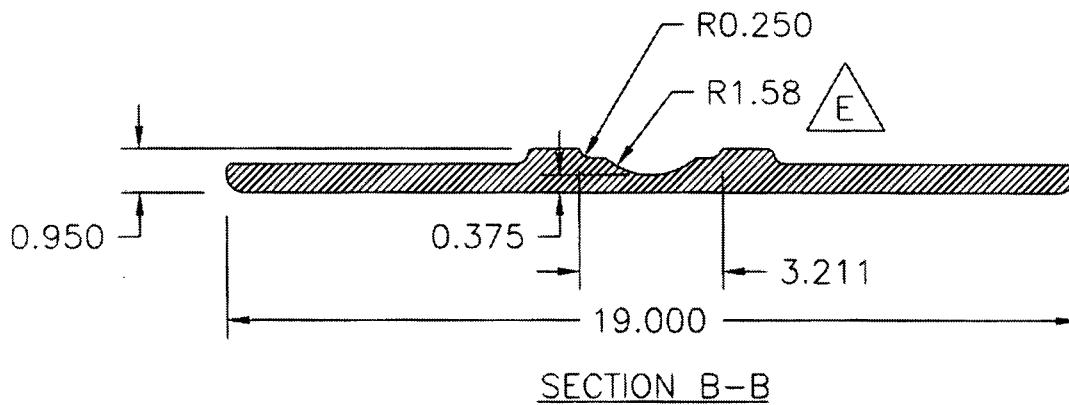
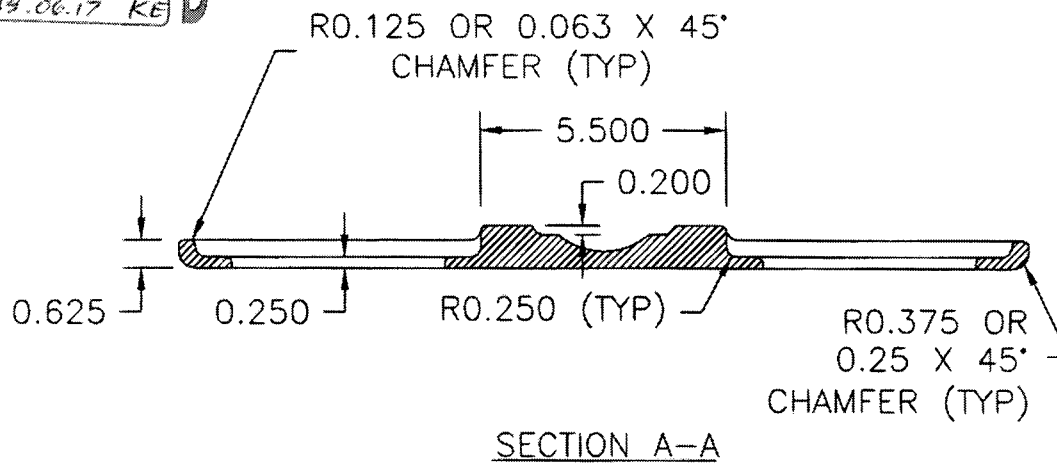
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED DIB	APPROVED KS	DRAWING NO. D2435	REV. E SHEET 2 OF 2
DATE 98.05.19		TITLE BEARPAW	SCALE 1:4

RELEASED  
98.06.17 KE



20923

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries